



MILD STEEL ELECTRODES

E7014

CWB to CSA W48-14
 Classification: E4914
 AWS/ASME A5.1 - 04 E7014

Suitable welding positions



Typical applications

Covering is iron powder, Titania type; common welding applications include fillet welding of structural steels for buildings, bridge, ship structures and general structures.

Characteristics on usage

- Very good striking and re-striking properties
- Excellent slag removal and good bead appearance
- Quiet and stable arc
- Re-dry the electrode at 120-150° C for 30 - 60 minutes prior to use

Typical chemical composition of all-weld-metal(%)

| C | Si | Mn | p | S | Cr | Ni | Mo |
|------|------|------|------|-------|------|------|------|
| 0.08 | 0.41 | 0.73 | 0.02 | 0.014 | 0.03 | 0.02 | 0.01 |

Minimum typical mechanical properties of all-weld-metal

| Yield Strength | | Tensile Strength | | Elongation | Impact Value |
|----------------|--------|------------------|--------|------------|--------------|
| 470 MPa | 68 ksi | 550 MPa | 80 ksi | 30% | 50J (0° C) |

Dimensions and recommended currents

| Vanguard Code | Diameter | | Length | | Amperage | |
|---------------|----------|-----|--------|-----|-----------|-----------|
| | inches | mm | inches | mm | F & HF | VU & OH |
| 6184 2400 | 3/32 | 2.6 | 13.8 | 350 | 60 - 100 | 50 - 90 |
| 6184 3200 | 1/8 | 3.2 | 13.8 | 350 | 90 - 140 | 80 - 130 |
| 6184 4000 | 5/32 | 4.0 | 13.8 | 350 | 140 - 200 | 110 - 170 |
| 6184 4800 | 3/16 | 5.0 | 13.8 | 350 | 190 - 240 | 150 - 200 |
| — | 1/4 | 6.0 | 20.0 | 450 | 250-310 | — |

Standard packaging

| Sleeve | | Master Carton | | Pallet | |
|---------|--------|---------------|--------|-----------|-----------|
| 4.5 Kgs | 10 Lbs | 22.5 Kgs | 50 Lbs | 1,125 Kgs | 2,500 Lbs |